

# Work Order ID 85098

\*85098\*

Page 1

June-01-12 3:43:43 PM

Item ID: D3405-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Lug Assembly

Start Date: 01/06/2012 Start Qty: 24.00

\*24\*

Cust Item ID:

Required Date: 15/06/2012 Req'd Qty: 24.00

\*24\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/04

Tooling:

Date:

Run Start \*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3405

Rev B

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3405

304 . 125

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

30

W12.07

IB12-6-7

IB12-6-7

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Brake NC	NC BRAKE	0.00							
Brake NC	Memo 1-Deburr 2-Form using DT8204 as per Dwg D3405 3- use DT9681 to check if correct forming	0.00				30			12/06/11
140 <b>*140*</b> QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00		5 r/bael12		30			
150 <b>*150*</b> Large Fab	Large Fab	0.00							
Large Fab	Memo Weld as per Dwg D3405 use DT8484 Identify as D3405-041	0.00				30			12-7-18

**Dart Aerospace Ltd**

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Item Name: Lug Assembly

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Start Date: 01/06/2012 Start Qty: 24.00

**\*24\***

Cust Item ID:

Required Date: 15/06/2012 Req'd Qty: 24.00

**\*24\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*160\***

QC

Memo

0.00

Quality Control

30x 12.7.18

DAS  
24  
9-89

170

QC5- Inspect part completeness to step on W/O

0.00

**\*170\***

QC

Memo

0.00

Quality Control

DAS  
16  
9-89

12/6/19

count

30

180

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

**\*180\***

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:30  
400 OF  
8:00

30x

MT  
12/07/19

W121841

**Dart Aerospace Ltd**

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Required Date: 15/06/2012 Req'd Qty: 24.00

\*24\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC3- Inspect Part Finish

0.00

\*190\*

QC

Memo

0.00

Quality Control

30 12-7-19

200

Identify as per dwg & Stock Location: SI 478 0.00

\*200\*

Packaging

Memo

0.00

Packaging

30x 12-7-19

210

QC21- Final Inspection - Work Order Release

0.00

\*210\*

QC

Memo

0.00

Quality Control

12/7/23 ME 12-07-20

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

June-01-12 3:43:47 PM

Page 1

Work Order ID: 85098

\*85098\*

Parent Item: D3405-041

\*D3405-041\*

Parent Item Name: Lug Assembly

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP A05.09.01New issueKJ/JLM  
IPP B 09.01.28 rev.B drawing EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3404-1		Manufactured	No			100	Each	43.0000	1	24			
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\*D3404-1\*

GHW Lug

\*\*

EL 12-7-17

85/100 x 30

Location

Loc Qty

Loc Code

WA

43

83879

43

M304S11GA

Purchased

No

150

sf

116.8900

0.154

3.890526

5,

\*M304S11GA\*

304/316 0.125 Sheet

\*\*

Bk-6-7

Location

Loc Qty

Loc Code

MAT020

116.89

121380

29.9

121780

86.99

12180

(30)

**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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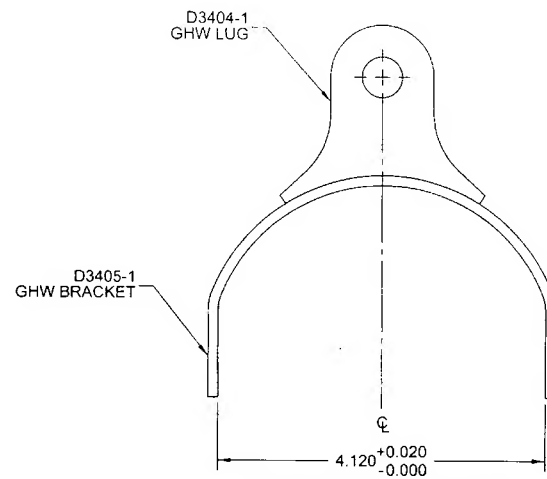
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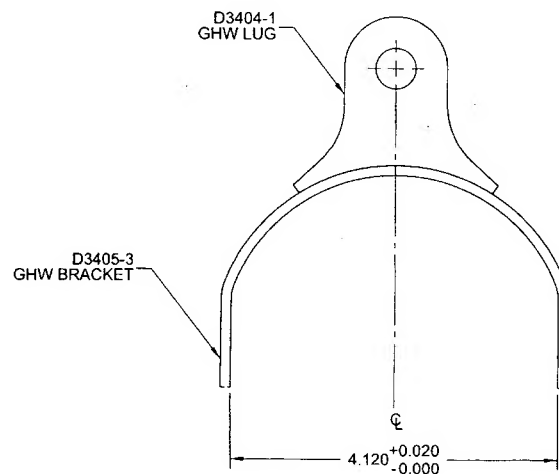
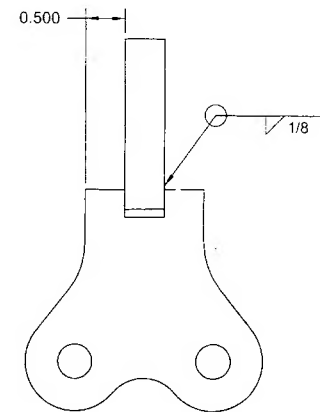
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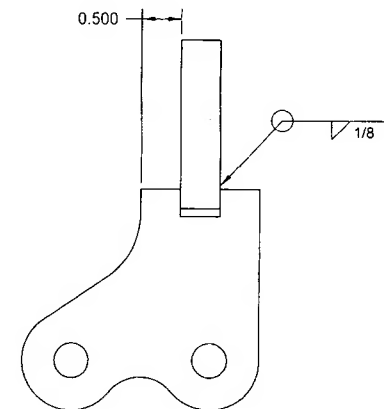
**NOTE:** Date & initial all entries



**D3405-041 LUG ASSEMBLY**



**D3405-043 LUG ASSEMBLY**



**RELEASED**  
06/12/18

DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
DATE	08.09.19	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

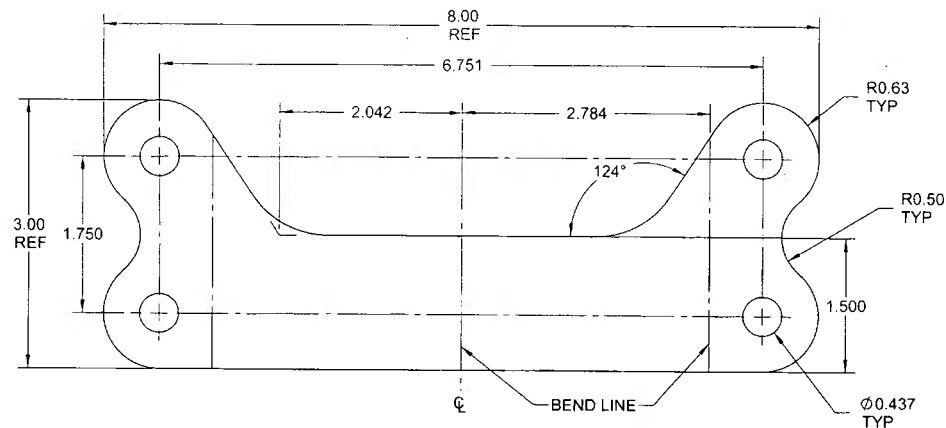
**Dart Aerospace Ltd**

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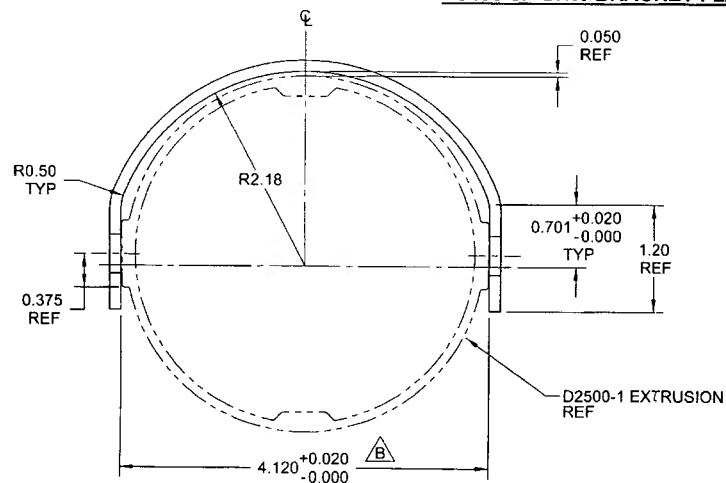
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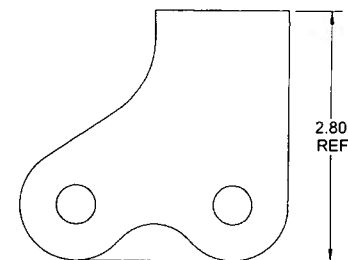
**NOTE:** Date & initial all entries



**D3405-3F GHW BRACKET FLAT PATTERN**



**D3405-3 GHW BRACKET**  
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

**RELEASED**  
08/12/18

DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3405	REV. B
MFG. APPR.			SHEET 4 OF 4
APPROVED		TITLE GHW LUG ASSEMBLY	SCALE NTS
DE APPR.		COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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